Work Orde November 23, 20	er ID 53922 009 2:50:11 PM	. //					:				Page 1
Revision ID:	D2530 B Handle Weldment		A	ccept	1884			S	Setup Sta		
Start Date: Required Date: Reference:	23/11/2009 Start Qty:				Cust Item II Customer:	<b>)</b> :				t	
Approvals:	Process Plan:QC:	Date:		Tooling:	Da		1		Run Sta Sta		
Sequence ID/ Work Center II	Operation D Description			Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr										
D2530	Rev B					· · · · · · · · · · · · · · · · · · ·	1				
Small Fab		lemo Cut to length as per I	Dwg D2536□2-De	0.00 0.00 SAO burr	09-12-10	<b>Q</b>		/6		_	
QC Quality Control		part completeness to s Iemo	tep on W/O	0.00	orlizlas		ı				
120 Small Eab- Small Fab	Large fab Small Eab	1emo	, 530 and QSI 004	0.00 0.00 using Welding Jig DT8:	301□2-Deburr		(	10x		4	(09/12

ALA SS. Rod Batch: MIOTZ13

<b>Dart Aerospace Ltd</b>	
---------------------------	--

W/O:			WC	RK ORDER CHAN	IGES					¥
DATE	STEP	PRO	CEDURE CHAI	NGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		·		•					-	
					j	:			·	·
Part No	<b>:</b>	PAR #:	Fault Cate	jory:	NCF	R: Yes N	lo <b>DQ</b>	<b>A</b> :	Date:	
	R	esolution:	Disposition	n:	QA:	N/C Clo	sed:	•	Date:	
NCR:		V	VORK ORDE	ER NON-CONFORM	MANCE	(NCR)				
DATE	STEP	<b>Description of NC</b> Section A	Initial Chief Eng	Corrective Action Se Action Description Chief Eng	ection B n	Sign & Date	Verific Section		Approval Chief Eng	Approval QC Inspector
,										
						,				

Work	Order	ID	53922
work	Oraer	117	コンソムム



Page 2

November 23, 2009 2:50:11 PM

Item ID:

D2530

Accept

Setup Start

Stop



**Revision ID:** Item Name:

В Handle Weldment

Start Date:

23/11/2009

Start Qty: 10.00

Req'd Qty: 10.00

**Cust Item ID:** 

**Customer:** 

Draw

Number

Reference:

Approvals:

Process Plan: \_\_\_\_ Date: \_\_\_

Tooling:

Date:

Run

Start



Required Date: 02/12/2009

\_\_\_\_\_ Date:\_\_

SPC (Y/N):

Set Up/

**Run Hours** 

Date:

Draw

Rev.

Stop



Sequence ID/ Work Center ID

130

Quality Control

**Operation** Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Memo

0.00

0.00

Qty Code

Plan

Reject Accept Qty

Reject Number

Insp. Stamp

09.12.14 (10)

140

QC

Quality Control

QC5- Inspect part completeness to step on W/O

2) Sor (12/14

0.00

150 Powdercoat

Powder Coating

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

0.00

M/09091.

Memo

320 DFINISH TIME

\_0.00 \_00ven temperature: BL 091-12- 14 \_3:15.

Dart Aerospace Ltd	t
--------------------	---

W/O:			WO	RK ORDER CHANG	ES			~ &
DATE	STEP	PR	OCEDURE CHAI	NGE	Ву	Date Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
				. '			•	
							• •*	
		1		·				
Part No		PAR #:	and the second s					
	Re	esolution:	Disposition	l:	_ QA: N/C Clo	sed:	Date: _	
NCR:			WORK ORDE	R NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC			ion B	Verification	Approval	Approval
DAIL	SILF	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Chief Eng	QC Inspector
•								
		***						
							·	
					`			

Page 3 November 23, 2009 2:50:11 PM Accept Item ID: D2530 Setup Start В **Revision ID:** Stop. Handle Weldment Item Name: **Start Oty: 10.00 Start Date:** 23/11/2009 **Cust Item ID:** 1. 3. **Required Date: 32/12/2009** Req'd Qty: 10.00 **Customer:** Reference: Start Run Tooling: Process Plan: Date: Date: Approvals: Stop SPC (Y/N): Date: Date: Reject Sequence ID/ Operation Set Up/ Draw Draw Plan Accept Reject Insp. **Work Center ID** Number Rev. Code **Qty** Qty Number Stamp Description Run Hours OC3- Inspect Part Finish 160 0.00 Memo Quality Control 170 Identify as per dwg & Stock Location: 0.00 mo 09/12/15! 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 180 0.00 Memo Quality Control

Dart A	erospace	<b>Ltd</b>
--------	----------	------------

W/O:			W	ORK ORDER CHANG	ES	<del>.</del>	<del></del>		- <del>. 4</del>	Constant of the
DATE	STEP	PRO	OCEDURE CH	ANGE		Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
		4:							,	
							•	<u> </u>		
							٠			
Part No	:	PAR #:	Fault Cat	egory:	_ NCI	R: Yes I	lo DQ	<b>A</b> :	_ Date: _	
		esolution:								
NCR:		·	WORK ORE	DER NON-CONFORMA	NCE	(NCR				
DATE	STEP	Description of NC		Corrective Action Secti	on B		Verific	ation	Approval	Approval
DATE	SIEP	Section A	Initial Chief Eng	Action Description Chief Eng		Sign & Date	Secti		Chief Eng	QC Inspector
				•			:			
				:						
·										
							<u> </u>			

## Picklist Print

November 23, 2009 2:50:18 PM

Work Order ID: 53922

Parent Item: D2530RevB

Parent Item Name: Handle Weldment

Comments:



Start Date: 23/11/2009

**Required Date: 02/12/2009** 

Page 1

Start Qty: 10.00

Required Qty: 10.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route. Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2534RevD		Manufactured	No			100	Each	29.0000	20.0000		Eple	09/12/
Lock Plate				Wareho	<u>use</u>	Loc (	<u>Qty</u>	Loc Code	 			

ST 5.

No

M304TR0.750W.049 Purchased

304 RD Tube .750 x .049W

Warehouse	<u>Loc</u>	<b>Oty</b>	Loc Code	-
<b>Location</b>				
Main Warehouse				1
ST		29		1
52569		29		i
	120	f	357.6711	30.6

(10) ld

SAD 09-12-10

Warehouse Location	Loc Oty	Loc Code	
Main Warehouse		}	
MAT	357.6711	1	
107518	2.77		
108498	0	•	
109314	8.5		
110113	0.73	1	
110271	0.03		
111096	9		
111457	11.43		<u> </u>
112652	85.89		
112800	239.3211		<u>30, 6</u>

\_\_\_\_\_

.

30,6787

erospa	

	-	-								
W/O:			WO	RK ORDER CHANG	SES				r	1
DATE STEP P		PRO	OCEDURE CHANGE			у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
							,	,		
								!		
· .							-			
	,								-	
					ļ					
								,		
Part No	•	PAR #:	Fault Categ	jory:	_ NCR: `	Yes N	lo <b>DQ</b>	<b>A</b> :	_ Date: _	:
	R	esolution:	Disposition	1:	QA: N/	C Clo	sed:		Date:	<del></del>
NCR:		V	VORK ORDE	R NON-CONFORM	ANCE (I	(CR)				
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification		Approval	Approval	
DATE	SIEP		Initial Chief Eng	Action Description Chief Eng	S   I	ign & Date	Section C	Chief Eng	QC Inspector	
				A 5 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 - 1 -						
	1									
					,					



	DESIGN DRAWN BY B WILLIAMS PH		DRAWN BY	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA				
		CED AN	APPROVED.	DRAWING NO. REV.	В			
		#	*	D2530 SHEET 1 OF	1			
	DATE			TITLE SCAL	Ε			
	04.1	2.14		HANDLE WELDMENT				
-	Α		96.06.18	NEW ISSUE				
	В		04.12.14	UPDATE NOTES AND DIMENSIONS				

O4.12.16

PART LIST -- D2530

QTY	PART NUMBER	DESCRIPTION
X -	-D2530	HANDLE WELDMENT
1	D2536	HANDLE
2	D2534	LOCK PLATE

SHOP COTY

RETURN 1

ENGINE RET

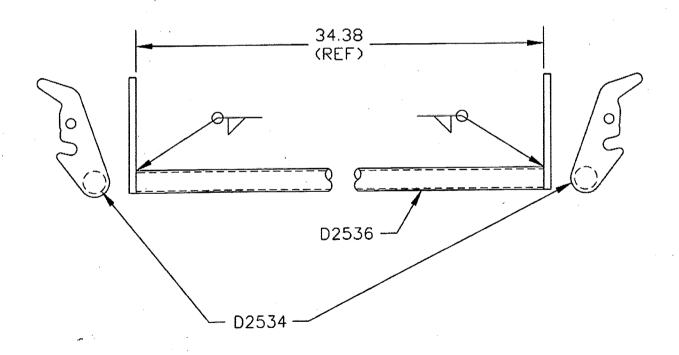
UNCONTROLL TO COMY

SUBJECT TO AME IDMENT

WITHOUT NO COTT

WORK OR HAR

NO 53922



## D2530 HANDLE WELDMENT

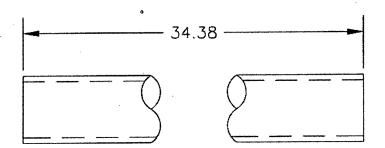
- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT BLACK (4.3.5.7) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



				The second secon
P	ESIGN	DRAWN BY	DART AEROSPACE	
lε	WILLIAMS	S PH	VICTORIA INTERNATIONAL AIRPOR	T. CANADA
C	HECKED.	APPROVED,	DRAWING NO.	REV. B
	-#	H	D2536	SHEET 1 OF 1
0	ATE		TITLE	SCALE
C	14.12.14		HANDLE	NTS
	ΑÏ	96.05.15	NEW ISSUE	
	В	04.12.14	UPDATE NOTES	

HELEASED

## REFERENCE ONLY



## D2536 HANDLE

- 1) MATERIAL: AISI 304/316 SS Ø0.75 X 0.049 WALL (REF. DART SPEC. M304TR0.750W.049)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED